

Work Order ID 71150

Thursday, June 23, 2011 12:36:27 PM



Page 1

Item ID: D3808-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Rail

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *11-06-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3808

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 16.125" long

ork 11/06/27

4

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA771 Rev: *AA* & Dwg D3808 Rev: *A* 12-Tap holes
for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 14-Deburr per dwg D3808

ork 11/06/29

4

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ork 11/06/29

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



B.A 11/06/30

4

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



H 0 BK 11-6-30

HandFinish

Memo

0.00

Hand Finishing

150

Identify as per dwg & Stock Location: 262

0.00



PJO =>

Packaging

Memo

0.00

Packaging

11/7/4

0 (4)

W/O: 71150		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/6/30	#145	QC3 inspect chem cal cart.	S	11/6/30	xy	N	S 11/6/30	
11/6/30	#145	ADD step for QC3	[Signature]			N	S 11/6/30	

Part No: D3808-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D3808-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Rail

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/h/4 J

CL 11/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:36:25 PM

Page 1

Work Order ID: 71150



Parent Item: D3808-1



Parent Item Name: Seat Rail

Start Date: 6/23/2011

Required Date: 7/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	26.3026	1.35	5.684211			



6061-T6 Bar 2.00 x 1.25

Location

Loc Qty

Loc Code

MAT010

26.30263158

114899

4.15263158

116623

2.15

118008

20

5.685 on 6/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

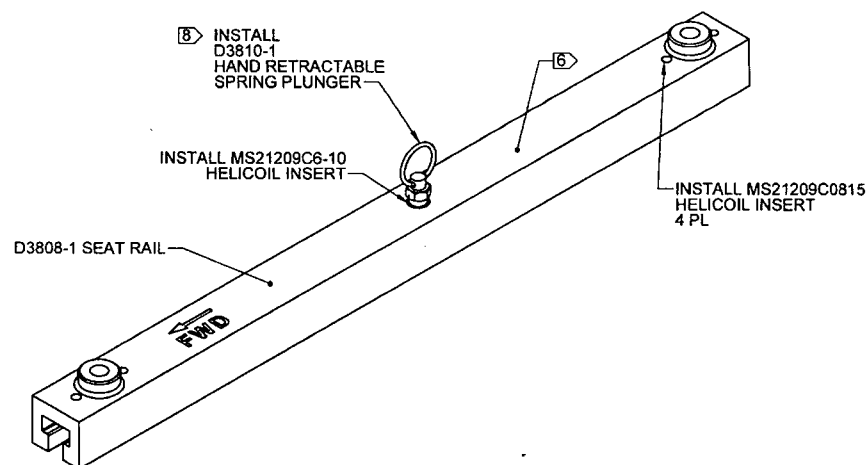
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NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		

RELEASED
08-09-2017

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3808** REV. A
SHEET 1 OF 2

TITLE **SEAT RAIL ASSEMBLY** SCALE NTS

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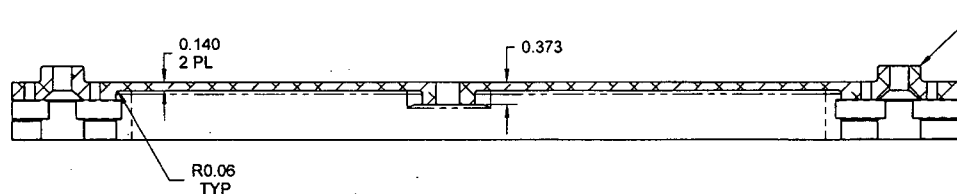
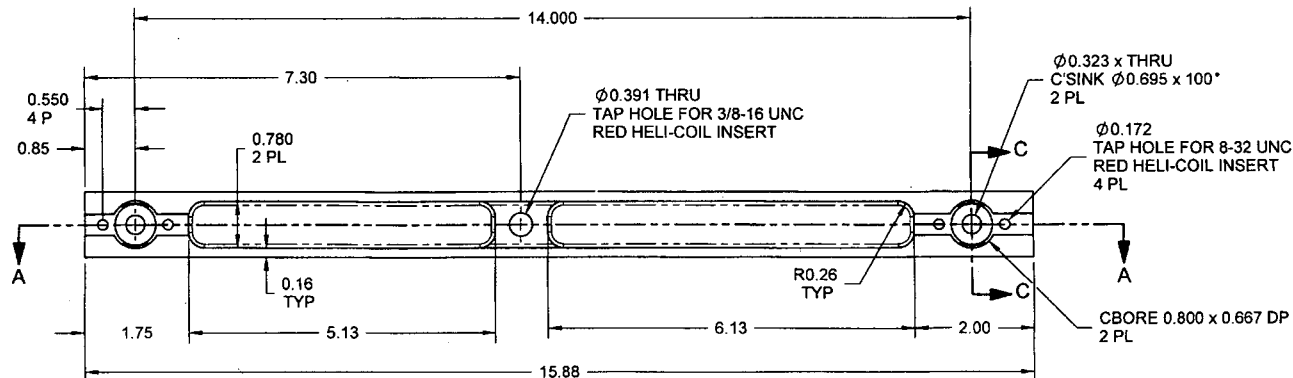
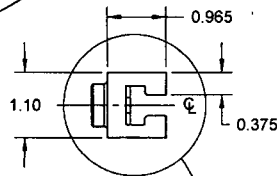
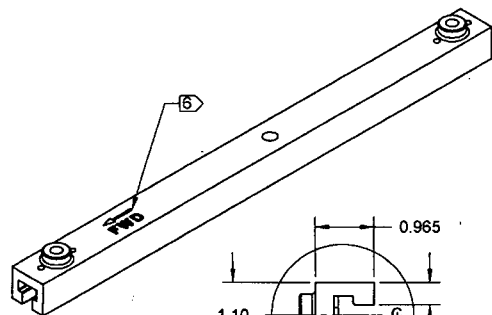
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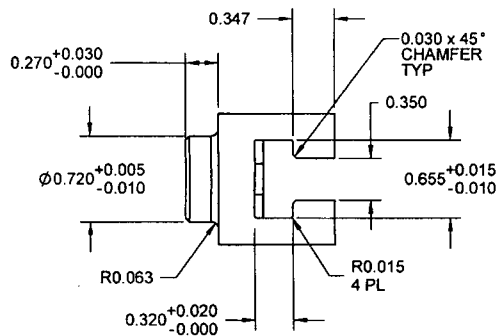
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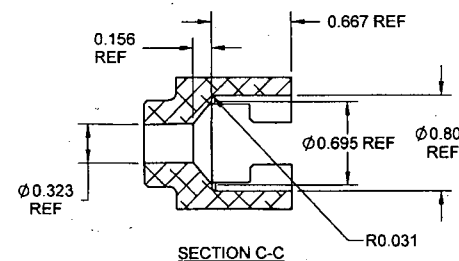


SECTION A-A

D3808-1 SEAT RAIL



DETAIL VIEW B



SECTION C-C

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED

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DART AEROSPACE LTD		Work Order: 71150
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	—		M-type	ML-2
7.30	+/-0.030	7.300	—		"	"
0.550	+/-0.010	.550	—		Vern	ML-7
0.85	+/-0.030	.857	—		"	"
0.780	+/-0.010	.780	—		"	"
Ø0.391	+0.006/-0.001	Ø.391	—		"	"
3/8-16 UNC	N/A	3/8-16 UNC	—			
Ø0.323	+0.006/-0.001	Ø.323	—		Vern	ML-7
Ø0.695 x 100°	+/-0.010 x 0.5°	Ø.693 x 100°	—		"	"
Ø0.172	+0.005/-0.001	Ø.173	—		"	"
8-32 UNC	N/A	8-32 UNC	—			
0.800 x 0.667 deep	+/-0.010	.800 x .662	—		"	"
2.00	+/-0.030	2.010	—		"	"
R0.26	+/-0.030	R.250	—		R-G	"
6.13	+/-0.030	6.120	—		Vern	CML-02
5.13	+/-0.030	5.120	—		"	"
0.16	+/-0.030	.161	—		"	ML-7
1.75	+/-0.030	1.757	—		"	"
15.88	+/-0.030	15.875	—		M-type	ML-2
0.965	+/-0.010	.962	—		Vern	ML-7
0.375	+/-0.010	.375	—		"	"
1.10	+/-0.030	1.101	—		"	"
0.140	+/-0.010	.146	—		"	"
0.373	+/-0.010	.378	—		"	"
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	—		"	"
R0.06	+/-0.030	R.060	—		R-G	
0.347	+/-0.010	.341	—		Vern	ML-7
0.270	+0.030/-0.000	.276	—		"	"
Ø0.720	+0.005/-0.010	Ø.721	—		"	"
R0.063	+/-0.010	R.063	—		R-G	
0.320	+0.020/-0.000	.322	—		Vern	ML-7
R0.015	+/-0.010	R.015	—		R-G	
0.655	+0.015/-0.010	.656	—		Vern	ML-7
0.350	+/-0.010	.349	—		"	"
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	—		"	"
0.667	+/-0.010	.663	—		"	"

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 7/150
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.156	+/-0.010	0.160	✓		Vern	ML-7
Ø0.695	+0.008/-0.001	Ø.695	✓		"	"
Ø0.323	+0.006/-0.001	Ø.324	✓		"	"
Ø0.800	+0.010/-0.001	Ø.799	✓		"	"
R0.031	+/-0.010	R.031	✓		R-G	

Measured by: ML	Audited by: B.A	Prototype Approval:	N/A
Date: 11/06/29	Date: 11/06/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	MS

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